

Work Order ID 67679

Tuesday, March 29, 2011 11:16:51 AM



Page 1

Item ID: D1048

Accept



Setup Start



Revision ID:

Item Name: Saddle

Stop



Start Date: 3/29/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

11-03-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D1048

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D1048

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

B11-3-29

(35)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-3-29

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/6/03/30

*can't
35

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67679

Tuesday, March 29, 2011 11:16:52 AM



Page 2

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.

= m. k 11/03/30

35X

140

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Form as per dwg D2010 using DT8053

= m. k 11/03/30

35X

150

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8407/30

35X

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Setup Start



Revision ID:

Stop



Item Name: Saddle

Start Date: 3/29/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>M 115178</i> Memo START TIME: <i>10:10</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>10:40</i>	0.00 0.00				<i>35</i>	<i>12</i>	<i>11-8-31</i>	
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>35</i>	<i>9</i>	<i>11/03/11</i>	
180 Packaging Packaging	Identify as per dwg & Stock Location <i>Sylvo</i> Memo	0.00 0.00		<i>count</i>		<i>11/4/11</i>	<i>5</i>	<i>5</i>	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Accept



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Item Name: Saddle

Start Date: 3/29/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/4/4
ME
11-04-01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 11:17:00 AM

Page 1

Work Order ID: 67679

Parent Item: D1048

Parent Item Name: Saddle



Start Date: 3/29/2011

Required Date: 4/1/2011



Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: B 02.02.22 Re-format NG

IPP Rev:C Now on Waterjet 06-12-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	4.0000	0.018	0.378947	1,		
304/316 Sheet .063													

FB11-3-29

Location

Loc Qty

Loc Code

MAT020

4

116623

4

116623

35

W/O:		WORK ORDER CHANGES						
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RELEASED
9/10/02 RCD

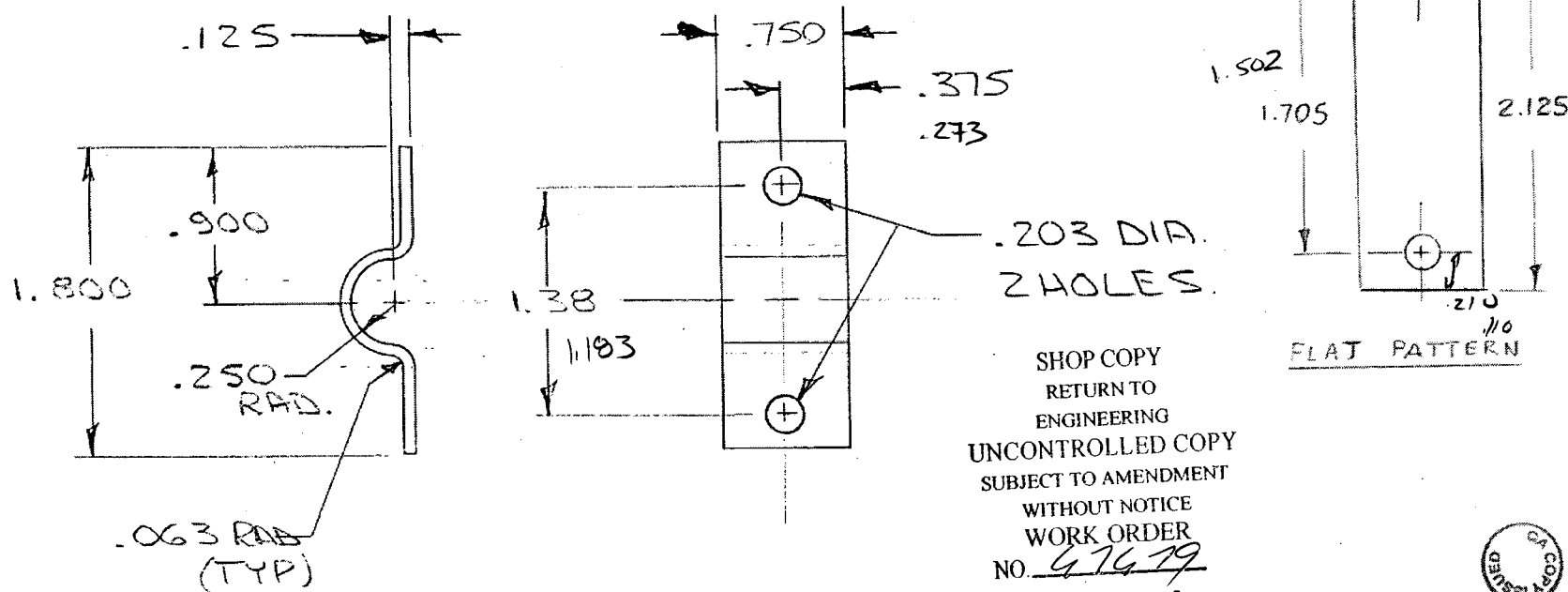
NOTES:

1) MATERIAL

STAINLESS STEEL
T304#2B .062 THICK

2) FINISH : POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)
PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47679

PL 11-03-29



A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
	RF		DRAWN	BASIC CODE	DIA. DASH NO. NO-HEAD NEAR SIDE F-HEAD FAR SIDE	CONTRACT NO.		DART AERO ACCESSORIES INC. VANCOUVER CANADA	
			APPROVED	D-DIMPLE DIGIT=NO OF SHEETS C-COUNTERSINK	LENGTH DASH NO. W-SPOTWELD	DRAWN	DATE		
			DESCRIPTION OF CHANGE	BASIC CODES		DESIGN		TITLE	
01.12.05 ADD FLAT PATTERN			BMM520470AD DB=MS20426AD		STRESS		CLAMP		
					CHECKED		CODE	DWG NO. D1048	REV A
					CLIENT		SCALE 1:1	SHT 1 OF 1	

REPORT ALL DISCREPANCIES - DO NOT SCALE

D1048

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